

Work Order ID 128678

January-22-15 7:37:30 AM

Page 1

350-591-108
B128678
RE-A
Accept

128678

Item ID: D350-591-133

Revision ID:

Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15 Start Qty: 5.00 *5*

Required Date: 1/30/15 Req'd Qty: 5.00 *5*

Reference:

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2946	Rev B
DSI9712	A

100 Document Control 0.00
DOCUMENT CONTROL
Memo 0.00
Doc.Control -USB or Paperwork Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

100

DC

SX

DAS
06
9-89

JAN 29 2015

110

110

Large Fab

Large Fab

Large Fab

Memo 0.00
1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr
Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.

DAS
24
9-89

JAN 26 2015

DAS
28
9-89

Dh 15/1/22

Work Order ID 128678

128678

Page 2

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Item ID: D350-591-133 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AFT Maintenance Step (Fits LH or RH)
 Start Date: 1/22/15 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				5	JAN 23 2015		DAS 24 9-89
130 *130* Large Fab Large Fab	Large Fab Memo 1-Deburr and Bevel ends for welding 2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946 A/RAluminum Rod 130855 3-Grind End Cap welds flush	0.00 0.00				5	JAN 23 2015		DAS 24 9-89
140 *140* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				5x			DAS 43 9-89 JAN 26 2015

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Item ID: D350-591-133

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: AFT Maintenance Step (Fits LH or RH)

Stop *NS2*

Start Date: 1/22/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 1/30/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC5- Inspect part completeness to step on W/O

0.00

150

QC Memo

0.00

Quality Control

5x

DAS
43
9-89

JAN 26 2015

160 Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish Memo

0.00

Hand Finishing

5x

DL 15/1/96

170 QC7-Inspect Chemical Conversion Coat

0.00

170

QC Memo

0.00

Quality Control

5

DAS
38

9-89

15-01-27

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Item ID: D350-591-133 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Maintenance Step (Fits LH or RH)
 Start Date: 1/22/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Large Fab	0.00							
180									
Large Fab	Memo	0.00							
Large Fab	Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.								
	A/R AL ROD BATCH: <u>3130855</u>								
190	QC10- Inspect visual per QSI004- ground welds	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

5x CC 15-1-27

5x **DAS 43 9-89** **JAN 27 2015**
~~**NOV 28 2014**~~

5x **DAS 43 9-89** **JAN 27 2015**

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Item ID: D350-591-133 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT Maintenance Step (Fits LH or RH)
 Start Date: 1/22/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Chemical Conversion Coat per QSI005 4.1	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing									
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220	<i>M 124808-</i>								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>9:10</i> OVEN TEMPERATURE: <i>320°</i> FINISH TIME: <i>9:40</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch <i>141311200</i>	0.00							
230									
HandFinish	Memo	0.00							
Hand Finishing									

5X *DL 15/1/27*

50 15-1-28. 23438

5x 4 15/1/28

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Item ID: D350-591-133 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: AFT Maintenance Step (Fits LH or RH)
 Start Date: 1/22/15 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-133								
	Location: <u>032</u>								
	PPP Rev: _____								
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

S DAS 06 9-89 JAN 29 2015
MCS 15-01-30
 W 15-02-30

Picklist Print

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Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:B05.10.14Modified step 10KJ/EC
IPP Rev:C06.07.19D2946 @ rev.b EC IPP REV:D
14.12.17 ADD DSI9712-011 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-11A		Purchased	No			250	Each	338.0000	4	20			
---------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

AN4-11A

BOLT

DAS

27

9-89

15/1/89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG 20

120731 20

ST325A 318

11921 1

M128362 300

M128769 17

DAS
28
9-89

AN4-14A

Purchased

No

250

Each

416.0000

8

40

AN4-14A

Bolt

DAS

27

9-89

15/1/89

DAS
06
9-89

Location

Loc Qty

Loc Code

FG 5

122141 5

ST325A 300

M131153 300

ST344 111

14600 1

M130716 110

DAS
28
9-89

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Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

AN4-16A

Purchased

No

250

Each

127.0000

8

40

AN4-16A

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

122

M131139

122

250

Each

131.0000

2

10

AN4-7A

Purchased

No

AN4-7A

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

ST345

131

16199

2

m126193

29

m131320

100

250

Each

389.0000

4

20

D2230-1

Manufactured

No

D2230-1

Mounting Lug

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST521

166

115306

80

116380

60

116381

26

ST546A

219

112595

1

113437

112

116381

89

116382

17

DAS

27

9-89

15/1/29

DAS
28
9-89

DAS

27

9-89

15/1/29

DAS
28
9-89

DAS

27

9-89

15/1/29

DAS
28
9-89

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Shop Packet Print

Page 2

Picklist Print

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Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

D2230-3

Manufactured No

250 Each

175.0000

4 20

D2230-3

Mounting Lug

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

7

114921

4

116378

3

ST525A

160

123324

160

D2622-120C

Manufactured No

110 Each

108.9200

0.52

3

D2622-120C

Step Extrusion

Location

Loc Qty

Loc Code

HALL

11

109575

11

WA003

97.92

125381

97.92

D2732

Manufactured No

250

f

821.0000

2

10

D2732

Rubber Extrusion

8x 050

DAS
06
9-89

Location

Loc Qty

Loc Code

ST412

471

117118

471

ST639

350

117118

350

cut (8) at 3.00"

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Shop Packet Print

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Picklist Print

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Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

D2734 Manufactured No

130 Each

58.0000

2 10

DAS
24
9-89

D2734

Step End Plate

**

JAN 29 2015

Location

Loc Qty

Loc Code

WA003

58

124317

37

125805

21

10

D2856-400

Manufactured No

250

f

67.2400

1.26

7

DAS
27
9-89

D2856-400

Abrasion Strip 4" Wide (Per Foot)

**

DAS
28
9-89

Location

Loc Qty

Loc Code

ST418

67.24

117887

67.24

7

(2X) 4.00" X 7.20" per dwg

D2944

Manufactured No

130

Each

24.0000

2

10

JAN 29 2015

DAS
24
9-89

D2944

Step Mounting Plate

**

Location

Loc Qty

Loc Code

WA003

24

126252

24

10

D2945

Manufactured No

250

Each

28.0000

1

5

DAS
27
9-89

D2945

Mounting Plate

**

Location

Loc Qty

Loc Code

ST014

8

112829

8

ST025A

20

126253

20

4

1

DAS
28
9-89

Picklist Print

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Page 5

Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

D3338-1 Manufactured No

Each 48.0000

D3338-1

Mounting Lug

**

DAS

27

8-89

15/1/29

DAS

28

8-89

Location

Loc Qty

Loc Code

ST527

48

127949

48

250

Each

3,016.000

14

70

**

DAS

27

8-89

15/1/29

DAS

28

8-89

MS21042L4

Purchased No

MS21042L4

Locknut

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

1729

m130799

1729

ST305

541

15924

8

426

426

m128300

8

m130922

99

m130799

20

Picklist Print

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Work Order ID: 128678

128678

Parent Item: D350-591-133

D350-591-133

Parent Item Name: AFT Maintenance Step (Fits LH or RH)

Start Date: 1/22/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

250

Each

5,041.000

14 70

NAS1149D0463.I

WASHER

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1167

16941

14

M129390

1153

ST269

3069

M129390

12

M130799

3057

DAS

27

8-89

15/1/29

DAS

28

9-89



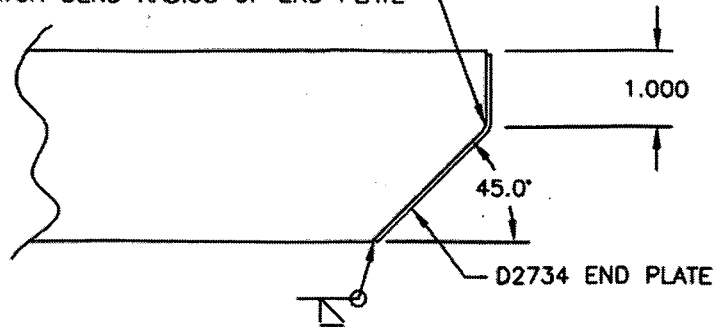
D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

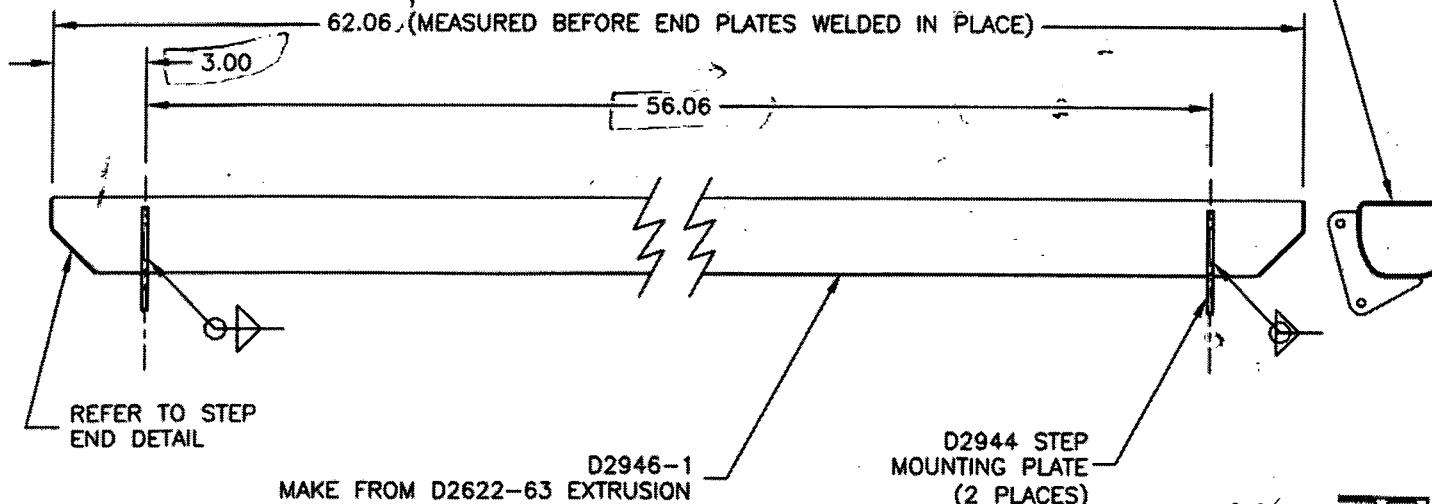
NOTE: ALL WELDS SHALL BE
100% VISUALLY
INSPECTED BY A
QUALIFIED INSPECTOR
PER DART QSI 004

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	PH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
dt	dt	D2946
DATE	TITLE	SHEET 1 OF 1
05.11.14	STEP ASSEMBLY	SCALE
A	99.12.13	NEW ISSUE
B	05.11.14	UPDATE FINISHING NOTE

RELEASED
05.11.28

W/0128678

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591
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**DAS
C3
0-89**

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: **G**
Date: 08.10.06

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

1.0 Purpose

It has come to DART's attention that it may be difficult to fasten the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Installations to the forward crosstube due to variations between crosstubes. For this reason, DART is adding the D3338-1 Mounting Lug to the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 004 and later.

For D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Step Kits at CHG 003 and earlier, DSI 9712-011 Mounting Lug Kit can be procured from DART. The kit contains all parts to upgrade a single step kit.

2.0 Installation

- 2.1 It is acceptable to install the D3338-1 Mounting Lug in lieu of the D2230-1 Mounting Lug as required to reduce the gap between step and the forward crosstube in accordance with the figures of this service instruction.
- 2.2 The height to set up the D350-591-133 Maintenance Step has been revised from 7.0in to 6.0in $\pm$ 1.0in to provide more flexibility. See sheet 2 of this service instruction.
- 2.3 In all other respects, install the D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps in accordance with Section 3.1 of Installation Instructions D350-591 or Section 32.1 of Instructions for Continued Airworthiness ICA-D350-591.

3.0 Parts List Change

The following additional part is provided with D350-591-133 Aft Maintenance Step and D350-591-213/-214 Heli-Access-Steps at CHG 004:

Qty -133	Qty -213	Qty -214	Part Number	Description
X			D350-591-133	Heli-Access-Step™, Aft Maintenance Step
	X		D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
		X	D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
1	1	1	D3338-1	MOUNTING LUG (ADD)

4.0 DSI 9712-011 Mounting Lug Kit Parts List

For existing D350-591-133 Aft Maintenance Steps and D350-591-213/-214 Heli-Access-Steps at CHG 003 or earlier, one DSI 9712-011 kit upgrades one step installation:

Qty -011	Part Number	Description
X	DSI 9712-011	Mounting Lug Kit
1	D3338-1	MOUNTING LUG

5.0 Weight and Balance

There is a negligible weight change associated with this modification.

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AIRCRAFT CERTIFICATION
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DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 14.12.04
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	MB	14.10.22
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>[Signature]</u>	DART AEROSPACE LTD	
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CHECKED	<u>[Signature]</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9712	SHEET 1 OF 3
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	INSTALLATION OPTION	NTS
DATE	14.10.22	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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REFERENCE ONLY

245
06
2-09

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
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DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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